

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave.St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001594**Date Inspected:** 11-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 830**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Gang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** 114-meter Mock-Up**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QA), M. Paul Stovall, was present at Zhenhua Port Machinery Company, (Z. P. M. C.), on Changxing Island, Shanghai, China for the purpose of monitoring the fabrication of the SAS/San Francisco/Oakland Bay Bridge.

No welding was performed.

114-meter Mock, Z. P. M. C. personnel are bolting splice connection plates onto the welded splice plates, then taking a drill bit to start bores in the un-drilled section of the bolted splice plate to use as a guide in lining up the template to start the remaining bolt holes. Z. P. M. C. personnel used hydraulic jacks to hold the bolted splice connection plates snug up against the welded splice connection plate.

While doing the above mentioned work, the QA Inspector measure the mismatch between the welded splice connection plate and the internally welded splice plate on the Mock-Up. The mismatch between the welded splice plate and the internally welded splice plate was measured at: 3 milli-meters (mm), 2 mm and 2 mm.

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# WELDING INSPECTION REPORT

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114-meter Mock-Up, lower section,  
with Hydraulic Jacks in place



114-meter Mock-Up, Welded Splice Connection Plate,  
with mismatch between it and the Internally Welded Splice  
Connection Plate  
lifting lugs being cut off of upper section of upper Mock-Up

## Summary of Conversations:

The QA Inspector had no substantial conversations.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Stovall,Paul	Quality Assurance Inspector
<b>Reviewed By:</b>	Cochran,Jim	QA Reviewer

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